

ABSTRACT

A clamp pallet (2) as a reference member is fixed to a table (1) of a machining center. A tapered positioning hole (12) is opened in a lower surface of a work pallet (3) as a movable member. An annular central pillar (21) is projected upward from the clamp
5 pallet (2), and an intermediate member (22) is arranged between the central pillar (21) and the positioning hole (12). The intermediate member (22) is composed of a shuttle member (23), which is diametrically expandable and contractible and supported on the central pillar (21) vertically movably, and a tapered cylinder (26), which is attached to an outer periphery
10 of the shuttle member (23) and makes a tapering engagement with the positioning hole (12). The shuttle member (23) is urged upward by means of an elastic member (24).